

Work Order ID 127146

December-09-14 11:02:27 AM

127146

Page 1

Item ID: D4776-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Skidtube Clevis

Start Date: 10/12/2014 Start Qty: 12.00

12

Cust Item ID:

Required Date: 16/12/2014 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4776	D

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut Blank at 4.400"

12

φ

Jfc 2014-12-09

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine per folio FB168

DWG REV: AA

FOLIO REV: AA

12

φ

14/12/15

2- deburr and break all sharp edges

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Item ID: D4776-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube Clevis

Start Date: 10/12/2014 Start Qty: 12.00

12

Cust Item ID:

Required Date: 16/12/2014 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

12 0 _____ WSP 14/12/15

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

OK 14/12/1612 0 _____ DAS 14 9-89

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

12x of all 14/12/15

127146

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N900040100

Setup Start *NS1*

Stop *NS2*

12

Cust Item ID:

12

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

150

0.00

12 ϕ 14-12-17. DAS 34 9.80

0.00

160

0.00

Q 14-12-17

0.00

170

0.00

Quality Control

12x ~~Ø~~ DAS
38
9-89 DEC 18 2014

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Item ID: D4776-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Skidtube Clevis
Start Date: 10/12/2014 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 16/12/2014 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location: <u>St129A</u>	0.00							
180									
Packaging	Memo	0.00							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

12 DEC 19 2014 **DAS 96 9-89**

15/1/15

4-12-19

Picklist Print

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T

Work Order ID: 127146

127146

Parent Item: D4776-3

D4776-3

Parent Item Name: Skidtube Clevis

Start Date: 10/12/2014

Required Date: 16/12/2014

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV A: NEW ISSUE JFS 13/03/07 VERIFY BY: JLM
REV:B 13.09.26 AS PER REV.B DD VERF:JLM
PER REV. PC1 JFS 13/11/07 VERIFY BY: JLM
IPP
IPP REV:C AS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.500X02.50 0		Purchased	No			100	f	51.6740	0.367	5			

M6061T6B1 500X02 500

**

6061-T6 Bar 1.50 x 2.50

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT004	51.674	
124572	1.35	
124681	3	
16742	9.38	
m128980	11.935	
m129530	5.05	
m129666	12	
<u>m129845</u>	8.959	

5 Jfe 2014-12-09

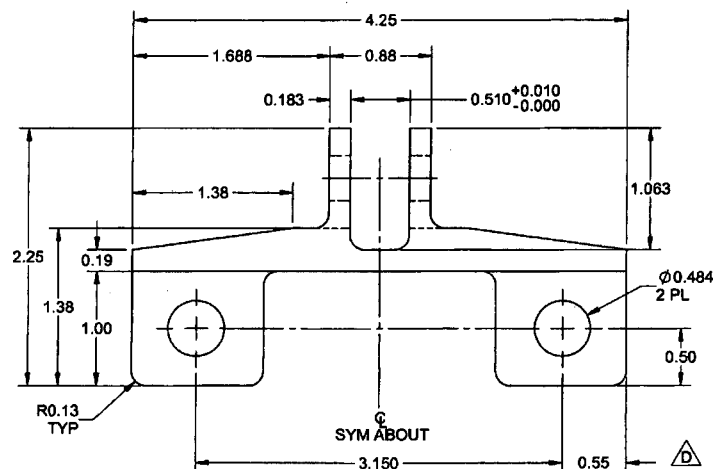
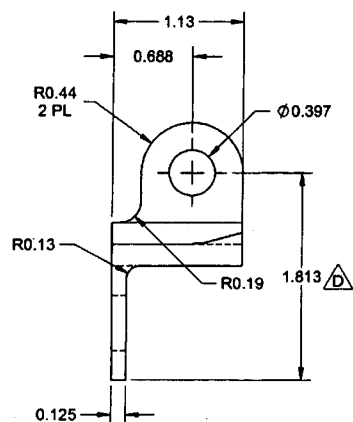
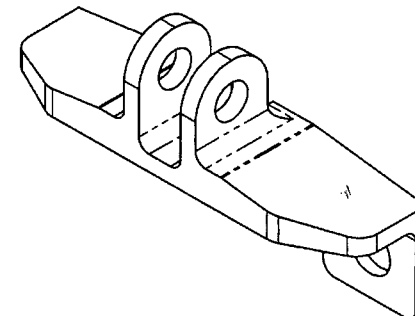
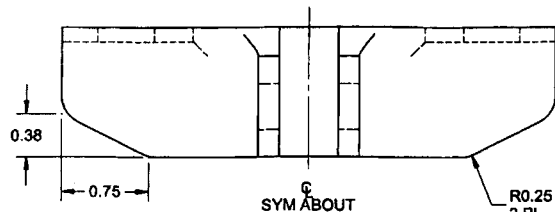
DART AEROSPACE LTD		Work Order:	
Description: Skidtube Clevis		Part Number:	D4776-3
Inspection Dwg: D4776	Rev: D	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.25	+/-0.030	4.250	✓		MJP-04	vern
2.25	+/-0.030	2.250	✓		31006	Height gauge
1.688 1.188	+/-0.010	1.685	✓		...	...
0.88	+/-0.030	0.877	✓		MJP-04	vern
0.510	+/-0.010	0.511	✓		---	gauge pin
1.063	+/-0.010	1.063	✓		MJP-04	vern
1.38	+/-0.030	1.381	✓		31006	Height gauge
0.19	+/-0.030	0.190	✓		MJP-04	vern
1.00	+/-0.030	1.002	✓		...	...
Ø0.484	+0.006/-0.001	0.486	✓		↓	↓
0.50	+/-0.030	0.501	✓			
0.550 0.53	+/-0.030	0.549	✓			
3.150	+/-0.010	3.150	✓			
1.13	+/-0.030	1.130	✓		↓	↓
0.688	+/-0.010	0.690	✓		31006	Height gauge
Ø0.397	+0.006/-0.001	0.398	✓		MJP-04	vern
R0.19	+/-0.030	0.190	✓		---	Radius gauge
R0.13	+/-0.030	0.130	✓		...	...
R0.44	+/-0.030	0.440	✓		...	...
0.125	+/-0.010	0.128	✓		MJP-04	vern
0.38	+/-0.030	0.380	✓		...	...
0.750	+/-0.010	0.750	✓		...	...
R0.25	+/-0.030	0.250	✓		...	...

Measured by: <i>[Signature]</i> Date: 14/12/14		Audited by: <i>[Signature]</i> Date: 14/12/16		Preliminary Approval: Date:	
Rev	Date	Change	Revised by	Approved	
A	14.08.27	New Issue	KJ	<i>[Signature]</i>	<i>[Signature]</i>

8 7 6 5 4 3 2 1



GRAIN
DIRECTION

RELEASED
2014-07-30

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8
(OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI 044 6.1
- 7) WEIGHT: 0.18 lbs

D4776-3 SKIDTUBE CLEVIS

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV.
MFG. APPR.	<i>[Signature]</i>	D4776	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET STRUT MACHINED PARTS	NT
DATE	14.07.14	COPYRIGHT © 2013 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1